Dart Aerospace Ltd.

Date: Tuesday, 23/12/2008 12:53:33 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 44285
Estimate Number : 10821
P.O. Number :
This Issue : 23/12/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : MACHINED PARTS
Previous Run : 43809
Written By :
Checked & Approved By :
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC
Est Rev:D As per Rev D 07-03-19 JLM

Drawing Name : SADDLE, INBOARD, RS, 206
Part Number : D26662
Drawing Number : D2666 REV.D
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 09/01/2009 **Qty:** 6 **Um:** Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	Saddle Billet

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
7075-T7351 2X6X6.25
Issue material from stock:
Cut Size 2.0 x 6.25 X 6.0
Grain Along Long 6.0 Length
Batch No: B34872 J.F. 08/12/29 (6)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program batch number.
1-Inspect part number and batch number are programmed correctly.
3-Fixturing Inspection last completed on N/A by removed.
4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
7- Deburr
P10
J.F. 08/12/29 (6)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet
J.F. 08/12/29 (6)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
09.01.05 ~~08.01.05~~	23	The fixture inspection is no longer necessary. Remove from the estimate. Perm. Change		09.01.05		09.01.05	09.01.05

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 12:53:33 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SADDLE, INBOARD, RS, 206

Job Number: 44285 **Part Number:** D26662

Job Number:

Seq. #:	Machine Or Operation:	Description :
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. 08/12/29 (6)

5.0	QC8	SECOND CHECK

Comment: SECOND CHECK J.L 08/12/29 (6)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 (6X)

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1 M-L 08/12/30

7.0	POWDER COATING	POWDER COATING M 109996 (6X)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:00
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:30 M-L 08/12/30

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT FL 08/12/30 (6)

9.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 426 SS 08/12/30 (X6)

10.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE D09/01/05 (6)
MF 08-12-31

Job Completion

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

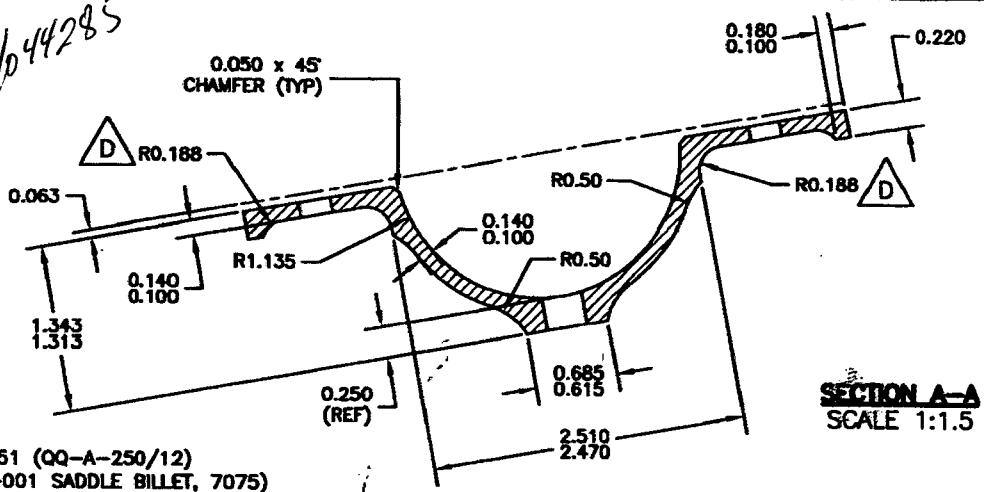
NOTE: Date & initial all entries

DESIGN	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD INSIDE HIGH	SCALE 1:3

A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095
D	06.11.08	R0.188 WAS R0.30; ø0.316 WAS ø0.313

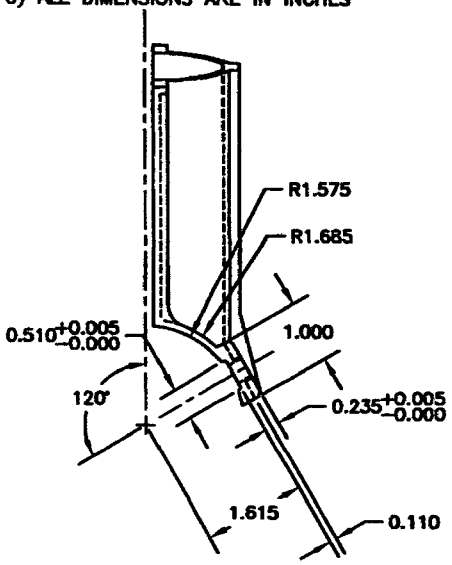
RELEASED
07.02.12

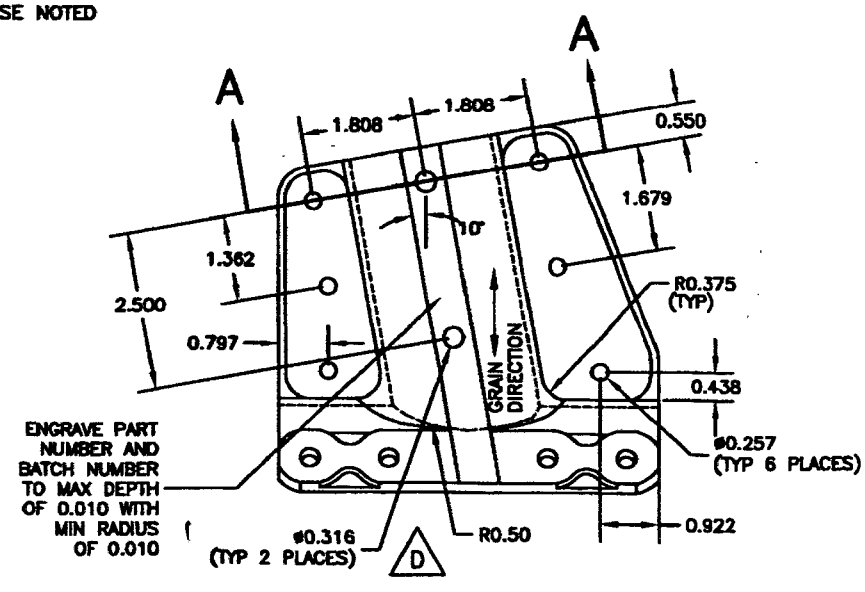
w/044285

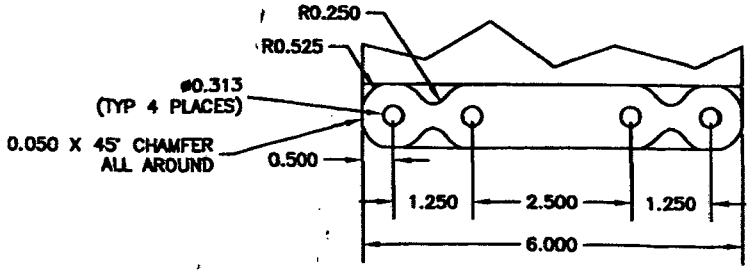


SECTION A-A
SCALE 1:1.5

NOTES:
1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.010 TO 0.020
5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
6) ALL DIMENSIONS ARE IN INCHES







D2666-1 SADDLE FWD INSIDE HIGH

DART AEROSPACE LTD	Work Order:	44285
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124"	.123"	.123"	.124"		
B	0.100	0.140		.109"	.109"	.108"	.107"		
C	2.470	2.510		2.492"	2.492"	2.492"	2.492"		
D	0.100	0.180		.135"	.135"	.135"	.135"		
E	0.210	0.230		.219"	.217"	.217"	.217"		
F	1.313	1.343		1.323"	1.323"	1.323"	1.323"		
G	0.240	0.260		.249"	.249"	.249"	.249"		
H	0.615	0.685		.651"	.651"	.651"	.651"		
I	1.125	1.145		1.136"	1.135"	1.134"	1.134"		
J	0.990	1.010		1.004"	1.004"	1.004"	1.004"		
K	0.235	0.240		.236"	.236"	.237"	.237"		
L	0.510	0.515		.510"	.510"	.510"	.510"		
M	0.100	0.120		.110"	.110"	.110"	.110"		
N	1.565	1.585		1.576"	1.575"	1.574"	1.574"		
O	5.990	6.010		5.999"	5.999"	5.999"	5.999"		
P	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
Q	2.495	2.505		2.501"	2.500"	2.500"	2.500"		
R	0.490	0.510		.501"	.501"	.502"	.502"		
S	0.313	0.318		Ø.314"	Ø.314"	Ø.314"	Ø.314"		
T	2.495	2.505		2.500"	2.499"	2.500"	2.499"		
U	1.357	1.367		1.363"	1.363"	1.363"	1.363"		
V	0.315	0.322		Ø.316"	Ø.316"	Ø.316"	Ø.316"		
W	0.540	0.560		.550"	.550"	.550"	.550"		
X	1.674	1.684		1.682"	1.680"	1.680"	1.680"		
Y	0.257	0.262		Ø.259"	Ø.259"	Ø.259"	Ø.259"		
Z	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F.
Date:	08/12/28

Audited by	JL
Date:	08/12/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

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Date:	08/12/29

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E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	